

Process Sheet

CU-DAR001 Dart Helicopters Services

Drawing Name : 206 L/L 1/L3 SCUFF PLATE, AFT RH

Estimate Number : 12273

P.O. Number : N/A

This Issue : 08/06/2007

Prsht Rev. : NC

First Issue : N/A

Previous Run : 32767

S.O. No. : N/A

Type : SMALL /MED FAB

Part Number : D206555009

Drawing Number : D206-555 REV C

Project Number : N/A

Drawing Revision : C

Material : N/A

Due Date : 30/06/2007

Qty: 10 Um: Each

Written By

Checked & Approved By

Comment

Est C 99.06.29 Returned to Electro Polish DM  
Est Rev:D Now on Waterjet 07-06-09 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Type Labels as per PPP D206-555-009

2.0 M304S25GA

304/316 .020" Sheet



Comment: Qty.: 0.8348 sf(s)/Unit Total : 8.3475 sf(s)

304/316 .020" Sheet

BATCH: M103508

3.0 WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D206-555

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/19	5	Split into	SB	07/10/19	1		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



## Process Sheet

DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, AFT RH

Number: 32767

Part Number: D206555009

Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Remove Tabs

Form parts on hydraulic press as per Dwg. D206-555 using DT 8324-9

Finish form on bench forming Jig DT 8325-9

SRB 07/08/10

Polish  
07-08-10

Polish

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/10

8.0

OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O:

Possible supplier: TOF Technologies

N/A

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

N/A

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/10/19 SP

①

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

7/10/19 SP

①

9:24:35 AM

## Process Sheet

DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, AFT RH

Number: 32767

Part Number: D206555009

Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



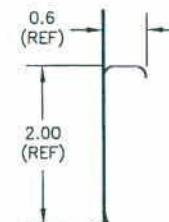
Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten:* (circled) 12/18/17

Job Completion



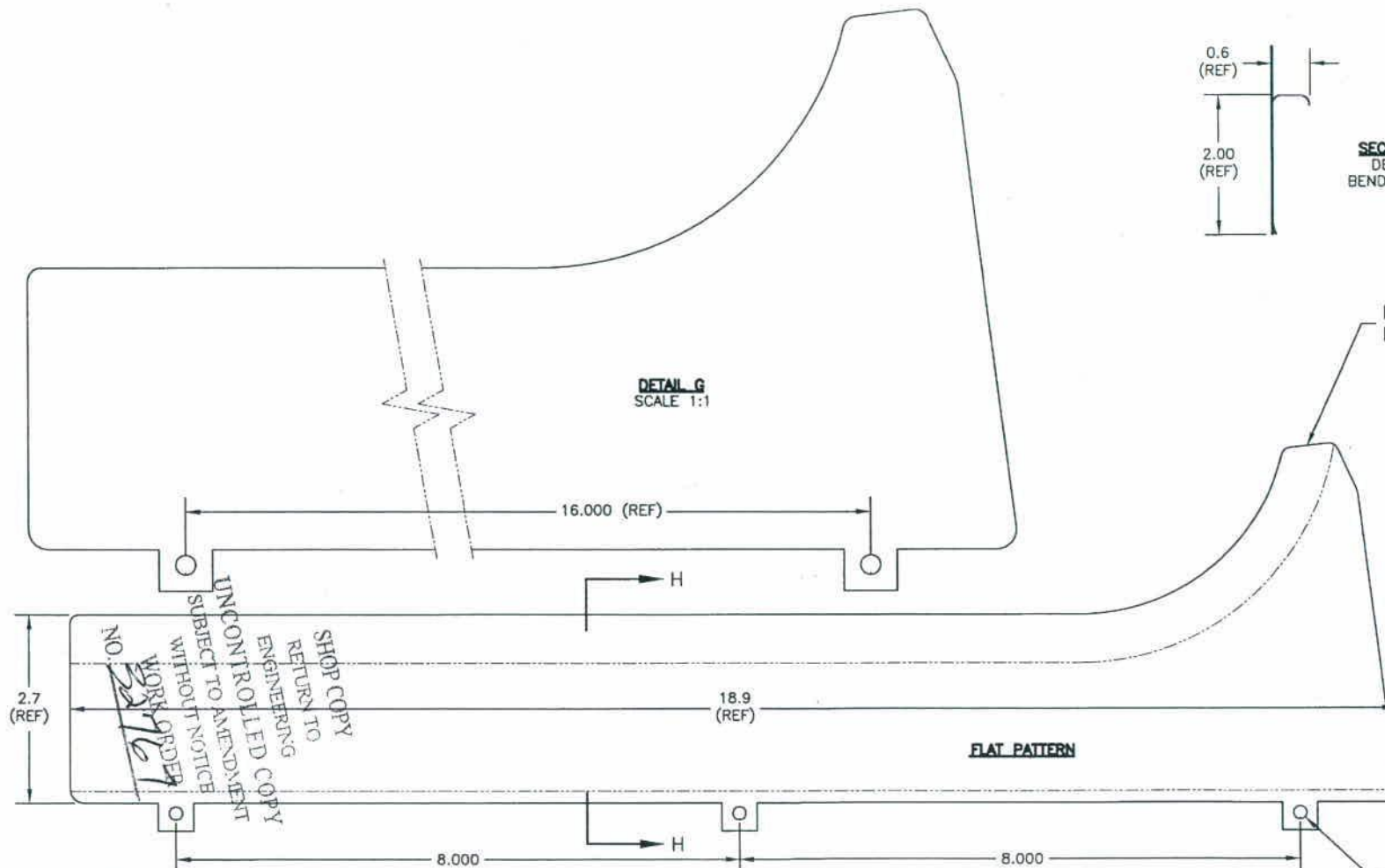
*Handwritten:* LE 17-10-19



SECTION H-H  
DETAIL OF  
BENDING SHOWN

REFER TO DETAIL G  
FOR 1:1 SCALE

DETAIL G  
SCALE 1:1



FLAT PATTERN

RELEASED

06.09.14

D206-555-009 (BEND IN DIRECTION SHOWN IN SECTION H-H)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T9
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) ~~FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES~~
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SEE W/O  
32907

DESIGN JB	DRAWN BY [Signature]	<b>DART</b> DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED [Signature]	DRAWING NO. D206-555	SHEET 6 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE 2:3



SPACE LTD

Work Order: 32761

Part Number: 0001 555-30

Revision Dwg: 0001 555 Rev: 1

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1. 12.188	+0.005 -0.000	12.188	✓		MT	
2. 2.7	+0.0100	2.7	✓		MT	
3. 18.75	+0.0133	18.75	✓		MT	
4. 8.000	+0.0010	8.000	✓		MT	
5. 8.000	+0.0010	8.000	✓		MT	
6. 16.000	+0.0010	16.000	✓		MT	
7.						
8.						
9.						
10.						
11.						
12.						
13.						
14.						
15.						
16.						
17.						
18.						
19.						
20.						
21.						
22.						
23.						
24.						
25.						
26.						
27.						
28.						
29.						
30.						

Measured by: [Signature]

Date: 07/06/13

Audited by: [Signature]

Date: 07/06/13

Prototype Approval:

N/A

Date:

N/A

Rev:

Date:

Change

New Issue

Revised by

KJ/RF

Approved